

Date: Tuesday, 08/07/2008 9:18:24 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	PLUG
Job Number :	40357		
Estimate Number :	13093		
P.O. Number :		Part Number :	D3492053
This Issue :	08/07/2008	Drawing Number :	D3492 REV C
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	C
Previous Run :	39017	Material :	
Written By :		Due Date :	28/07/2008
Checked & Approved By :	JLD 08.7.08	Qty:	20
Comment :	Est Rev:A New Issue 06-06-20 JLM Est Rev:B as per Rev C 07-12-06 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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Comment: Qty.: 0.0481 f(s)/Unit Total: 0.9618 f(s)
 6061-T6 Round Bar .750"
 (M6061T6R0750)
 Batch: M102857

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA715 & Dwg D3492
 Dwg Rev: C
 Folio Rev: AA

PTO
 →

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
01.07.03	2	DIM $\phi 0.520$ NOW $\phi 0.510$ PERMANENT CHANGE	RE	01.07.03	ALL	RE 01.07.03	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/07/2008 9:18:24 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 40357

Part Number: D3492053

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



248

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

2M/H 08/07/05

7.0

POWDER COATING

POWDER COATING



M107925

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

START TIME:

7:30am

OVEN TEMPERATURE:

320°F

FINISH TIME:

8:00am

JH 08-07-16

244

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



244

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-H 08/07/16

9.0

NAS1611012

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-012 O-RING

M108038

JH

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube
A/R 55-O'Ring Lube Batch: M101223

JH 08-07-16

244

11.0

QC5

INSPECT WORK TO CURRENT STEP



counted

Comment: INSPECT WORK TO CURRENT STEP

S 08/07/16

244

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP-A

JH

08-07-16

244

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/07/2008 9:18:24 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services.

Drawing Name: PLUG

Job Number: 40357

Part Number: D3492053

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/17/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

0.510
08.07.03

☒ **First Article** ☐ **Prototype**

Measured by: J.F.	Audited by: RQ	Prototype Approval: N/A
Date: 08/07/14	Date: 08/07/14	Date: N/A






Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	DS

P/O D3492-053

[illegible]

NOTES:
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE

DESIGN		  	DART AEROSPACE LTD
DRAWN			HAWKESBURY, ONTARIO, CANADA
CHECKED			DRAWING NO
MFG. APPR.			D3492
APPROVED			TITLE
DE APPR.		PLUG	SCALE
			2:1

DATE 07.10.05

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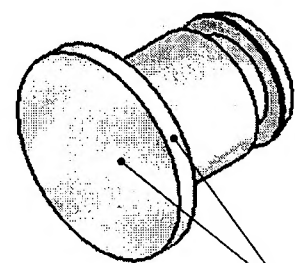
UNDER REVIEW

08-07-01

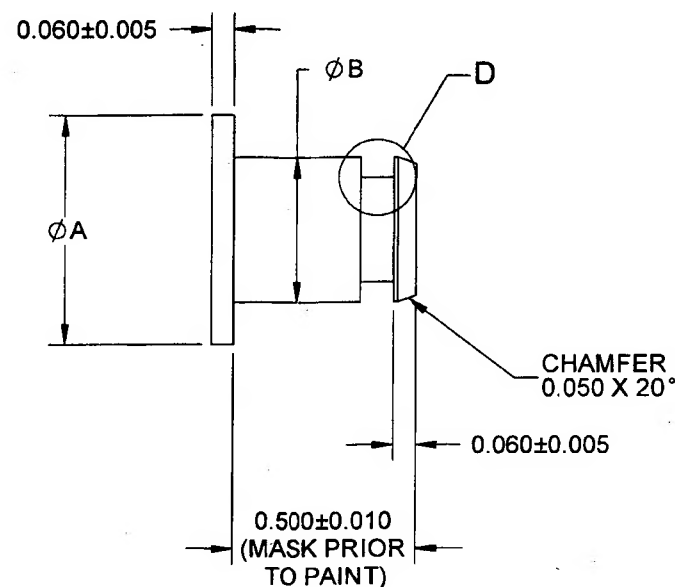
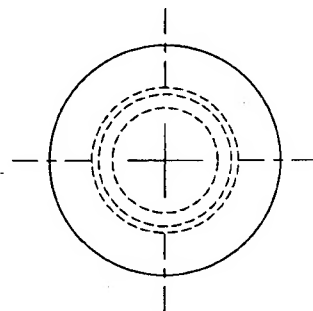
01-04-01

DIW OF IN 0998-13

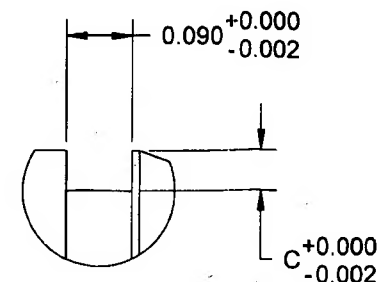
(WHITE SHUTTLE)



POWDER COAT THESE
FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750







NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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06.07.07
UNDER REVIEW
01.04.11
DIM ØB ON D3492-13
RES. QX (MAKE SMALLER)

RELEASED
07.11.16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3492	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	4:1
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